



Dart Aerospace Ltd.
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Tel (613) 632-5200

D206-559-031
Job Sheet 181024



Part No: D206-559-031

Job Qty: 2 ea

Part Name: 206A/B Bearpaw Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 7/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV L SHEET 7 IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev B 10.10.04 per DSI9527
EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Stores/Pkg-2		JUL 20 2018
107	Packaging	2 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-2		JUL 20 2018
110	QC	2 pcs	7/20/18	7/20/18	0.00	0.00	QC4		JUL 25 2018
115	DC	2 pcs	7/20/18	7/20/18	0.00	0.00	DC		JUL 25 2018
120	Packaging	2 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		JUL 25 2018
130	QC21-FG	2 Ea	7/20/18	7/20/18	0.00	0.00	QC21		JUL 25 2018

Part Op 107 - Pick Kit

Descriptions: 110 - QC4- 100% Inspect kits for completeness

115 - Document Control Photocopy bluefile and type labels per PPP D206-559-031 CHG 002

120 - Identify as per dwg & Stock Location: Identify and pack for shipping as per PPP D206-559-031 and
DSI9430 Location: FG128 PPP Rev:

130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-17A	Bolt	16 Ea (8 ea)	90-Start up Operation	5070192
AN4-20A	Bolt	16 Ea (8 ea)	90-Start up Operation	5087308
D3860-041	Wearplate Weldment	4 Ea (2 ea)	90-Start up Operation	11451267x2
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5087365
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	5062379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-17A	16	250	0
	AN4-20A	16	88	0
	D3860-041	4	9	0
	MS21042L4	16	3,474	0
	NAS1149D0463J	16	11,376	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition	
 Container No: S094378 206A/B Bearpaw Wearplates PART NO: D206 – 559 – 031 Serial No/Batch: S094378 Revision: Operation: Packaging Change No: CHG002		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 – 5200 Email: sales@dartaero.com www.dartaerospace.com
		Completed By _____
		Lead hand / Supervisor Approval Verification _____
		QC / QA Coordinator Approval _____

Root Cause					
Environment ☐	No Re-verification ☐				
Design ☐	Operator ☐				
Doc/Data ☐	Offset/Setup ☐				
Equip/Tooling ☐	Supplier ☐				
Handling/Pre ☐	Training ☐				
Material ☐	Use for Testing ☐				
Internal Transport ☐	Poor Information ☐				
Tribal Knowledge ☐	Rushing ☐	Crushing ☐	Countersink ☐	Off-set ☐	
LOA ☐	Product Improvement ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	
Substation ☐	Process Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	
Past Expiry Date ☐	Manufacturing Process ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	
Misidentified ☐	Past Due ☐	OTHER : _____			

- ☐ Positioned Wrong
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Drawing
- ☐ Finish
- ☐ Misread
- ☐ Turning Sequence

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

REFERENCE ONLY